Contract for the Design, Construction and Operation of the Elwood Ordnance Plant for the loading of Fixed Rounds, Shells, Bombs, Boosters, and Fuzes, including the manufacture of Amatol and Nitrate of Ammonia, was executed on September 19, 1940, by Lt. Col. L. H. Cambell, Jr., Contracting Officer for the Ordnance Dept and the Partnership of Sanderson & Porter, 52 Williams St., New York City.

The original contract requirements called for the construction and equipping of a Plant having an estimated monthly capacity based on working 500 hours per month, as follows;

750,000 - Fixed Rounds 75mm H.E. or 3" AA H.E. or equivalent explosives capacity of other similar types.

175,000 - 155mm H.E. or equivalent explosives capacity of other similar types.

60,000 - 100 lb. bombs or equivalent explosives capacity of other similar types, and corresponding boosters and fuzes for the foregoing types of Ammunition.

The Plant to consist of three operating lines (one for each of the three types of Ammunition above mentioned) and appropriate lines for the corresponding boosters and fuzes and to include loading buildings, Nitrate of Ammonia evaporating and graining buildings, Administration buildings, shops, railroads, roads, steam lines, air lines, electric system, telephone lines, fencing, lighting, power house, dormitories, water system, staff dwellings, mess hall, cafeterias, guard quarters, fire fighting and housing thereof, and other buildings together with all necessary equipment necessary or appropriate for a loading plant of the approximate capacity aforesaid, with storage buildings adequate for about 30 days' supply of incoming materials, and about 60 days' production of finished product; the plant to conform insofar as is practicable, with the typical designs, drawings, specifications, details and standards which were on file in the office of the Quartermaster General or Chief of Ordnance.

Supplements to the original contract from time to time provided for additional facilities at the plant, the principle ones of which comprised the following including provision of additional facilities required, such as utilities, highways, storages, etc.

Group 3A

Group 8

Group 9

Group 27 - 22 buildings 50 x 500'0"

Expanded facilities for increased production in Groups 1, 2, 3 & 3A

Conversion of a portion of Group 61 into an Ammunition Renovation Plant.

Because of difficulties in acquiring property, the first actual construction work on the site of any of the loading lines was the beginning of work on the site of Group 2 on November 18, 1940. This loading line was the first of all the loading lines authorized by the Government to be built for the World War II program to produce ammunition. The elapsed time from the date of starting on November 18, 1940 to the production of completed ammunition on July 12, 1941, was 7 months and 24 days.

Following is a tabulation of initial construction dates and actual dates of loading the first completed ammunition for each of the loading lines;

Group	Date Started Construction	Date Placed in Operation	Loading
2	Nov. 18, 1940	July 12, 1941	155MM Shell
3	Jan. 15, 1941	Aug. 19, 1941	Bomb, Demolition, 300#, M31
1	Jan. 2, 1941	Sept. 19, 1941	Round, Complete Shell, H.E., for Howitzer, 105MM, M2
4	Apr. 16, 1941	Dec. 12, 1941	Fuze, P.D., M48
7	Apr. 16, 1941	Dec. 29, 1941	Booster, M21
61	June 11, 1941	Jan. 20, 1942	Ammonium Nitrate Liquor Evaporation and Crystallization
5	May 7, 1941	Apr. 1, 1942	Fuze, P.D., M51
8	July 15, 1941	March 9, 1942	Artillery Primer, M1B1A2
3A	Aug. 4, 1941	Apr. 16, 1942	Bomb, G.P., 1000# M44
6	May 7, 1941	Apr. 20, 1942	Auxiliary Booster M104 Fuze, Bomb, Nose AN-M103 Booster, M20
9	Aug. 5, 1941	Apr. 28, 1942	Detonator M15, Detonator for M20 Booster, and Detonator for M48 Fuze

The following are some interesting data regarding the plant;

Group	Item	No. of Bldgs.	Floor Area
1	Semi-Fixed Ammunition Loading Line Semi-Fixed Shells 75MM to 105MM	81	265,420 Sq. Ft.
2	Medium Calibre Loading Line Non-fixed shells - 155MM, Anti Tank Mines and 100 to 250 Lb. Bombs	60	231,399 Sq. Ft.
3	Demolition Bomb Loading Line Demolition Bombs - 100 Lb. and up	63	158,940 Sq. Ft.
3A	Demolition Bomb Loading Line Demolition Bombs - 500 lbs. to 4,000 lbs.	61	206,145 Sq. Ft.

The following are some interesting data regarding the plant;

MAJOR LOADING LINES

Group	Item	No. of Bldgs.	Floor Area
1	Semi-Fixed Ammunition Loading Line Semi-Fixed Shells 75MM to 105MM	81	265,420 Sq. Ft.
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3A	Demolition Bomb Loading Line Demolition Bombs - 500 Lbs. to 4,000 Lbs.	61	206,145 Sq. Ft.
	ACCESSORY LOADING		
4	Fuze Loading Line	73	76,061 Sq. Ft.
5	Fuze Loading Line	34	66,658 Sq. Ft.
6	Booster Loading Line	29	51,917 Sq. Ft.
7	Booster Loading Line	28	46,128 Sq. Ft.
8	Primer Loading Line	25	41,687 Sq. Ft.
9	Detonator Loading Line	49	94,007 Sq. Ft.
	MISCELLANEOUS GROUP AREAS		
20	Sewage Treatment Area	5	16,972 Sq. Ft.
21	North Substation	1	512 Sq. Ft.
22	South Substation	1	512 Sq. Ft.
23	Miscellaneous Buildings	38	19,478 Sq. Ft.
24	Fire Station	1	7,301 Sq. Ft.
26	Salvage Yard	11	10,567 Sq. Ft.
27	Inert Storage Warehouses	24	552,332 Sq. Ft.
60	Administration Area	72	167,155 Sq. Ft.
61	Nitrate of Ammonia Preparation Area Later converted to Renovation Plant	24	56,015 Sq. Ft.
62	Inert Storage Warehouses (Brick)	26	506,589 Sq. Ft.
63	High Explosives Igloos	81	95,167 Sq. Ft.
64	Finished Ammunition Warehouses	38	385,415 Sq. Ft.
65	Smokeless Powder Igloos	35	80,202 Sq. Ft.
66	Finished Ammunition Igloos	91	159,738 Sq. Ft.
66A	Finished Ammunition Igloos	43	75,827 Sq. Ft.
67	Radio Transmitter Building	1	120 Sq. Ft.

Group	Item	No. of Bldgs.	Floor Area
68	Fuzes, Primer & Booster Igloos	25	42,374 Sq. Ft.
70	Shop Area	34	75,310 Sq. Ft.
71	Chemical Lab. & Miscl. Bldgs.	16	8,037 Sq. Ft.
73	Construction Headquarters	11	33,926 Sq. Ft.
74	Residences Along Highway 66A	19	16,365 Sq. Ft.

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Total Acreage	-	16,000
Buildings and Structures	-	1,100
Fences	-	60 Miles
Roads	-	101 Miles
Railroads	-	112 Miles
Electrical Distribution and Transmission Lines	-	66 Miles
Street and Fence Lighting	-	83 Miles
Maximum Electrical Demand	-	4,064 Kilowatts
Maximum Kilowatt Hours of Power per Month	-	2,299,200

Water Storage consisted of the following;

4 - 150,000 Gal. Steel Overhead Storage Tanks

1 - 1,000,000 Gal. Ground Reservoir

Kemery Dam Emergency

Water Storage - 26,000,000 Gal.

Water Treatment Plant with Water Softening

Daily Capacity at maximum efficiency - 1,500,000 gallons.

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PERSONNEL:
Maximum number of employees was reached on September 19, 1942, and was divided as follows:

Construction	718
Operations	12,624
Total Assigned Personnel	13,342

Contract W-ORD was terminated as of August 15, 1945, by the following directives;

ARMY SERVICE FORCES
OFFICE OF THE CHIEF OF ORDNANCE
FIELD DIRECTOR OF AMMUNITION PLANTS
ST. LOUIS 8, MISSOURI

In Reply
Refer To: SPOLY-G
Legal Section

15 August 1945

Parsons/ap
Notice of Termination
Contract No. W-ORD-476

Sanderson & Porter
Elwood Ordnance Plant
Joliet, Illinois

Attn: Mr. Harrison Smith

Re: Termination of Work under Contract No. W-ORD-476, As Amended.

Gentlemen:

Confirming previous notice, the work under Contract No. W-ORD-476 is terminated for the convenience of the Government. Such termination is effective as of August 15, 1945.

You are requested to furnish promptly an estimate of the cost of the work to be done as a result of this notice of termination (including the cost of decontaminating the Plant). A fixed-fee for your services rendered as a result of this notice of termination will be negotiated after receipt of said estimate.

FOR THE CHIEF OF ORDNANCE:

Yours very truly,

John K. Willard
JOHN K. WILLARD
Lt Col, Ord Dept
Executive Officer
Field Director Ammunition Plants
Contracting Officer

Receipt is hereby acknowledged of the above Notice of Termination to Contract No. W-ORD-476, dated September 19, 1940, as amended, and the Contractor hereby accepts the terms and conditions thereof.

Date: August 17, 1945

SANDERSON & PORTER

By Harrison Smith

KXVO

CD29JEEJ

UCGX V UZVO NR 26 WD P

-T- ELWD ILL 832

FROM GERBER FLD DIR AMM PLTS ST LOUIS MO 150715Z AUG 45

TO C O ELWOOD ORD PLT JOLIET ILL

GR NC

YOU ARE DIRECTED TO ORDER YOUR CONTRACTOR TO CEASE ALL PRODUCTION AT YOUR FACILITY IMMEDIATELY AND YOU WILL INITIATE ACTION TO PLACE V-J DAY PLANS AS OUTLINED IN RR&D LETTER 6-45 DATED 10 AUGUST 45 INTO EFFECT CONTRACTOR'S HOME OFFICE BEING NOTIFIED BY THIS OFFICE ACKNOWLEDGE RECEIPT OF THIS TELETYPE END SPOLY-A STRATTON TT 48343

0830Z

CF4K

UCGX V UZVO NR 113 WD R

-T- ELWD ILL 832

FROM GERBER FLD DIR AMM PLTS ST LOUIS MO 132126Z AUG 45

TO C O ELWOOD ORD PLT JOLIET ILL

GR NC

YOU WILL INSTRUCT YOUR CONTRACTOR TO CANCEL ALL WORK INCLUDING PROCUREMENT OF EQUIPMENT IN CONNECTION WITH DESIGN AND CONSTRUCTION OF ALL PRESENTLY APPROVED PROJECTS AND SITE LETTERS AT YOUR ESTABLISHMENT EXCEPT WORK NECESSARY FOR PRESERVATION OF EQUIPMENT AND PROPERTY CORPS OF ENGINEERS HAS BEEN NOTIFIED TO CANCEL THAT WORK IN WHICH THEY HAVE AN INTEREST END SPOLY-A STRATTON TT 48130

2125Z

THE FOLLOWING LIST REPRESENTS THE TOTAL AMOUNT OF ALL ITEMS PRODUCED AT THE ELWOOD ORDNANCE PLANT DURING THE LIFE OF THE CONTRACT

ITEM	TOTAL PRODUCTION
GROUP 1.	
105MM Shell M48 Amatol M2	4,760,865
105MM Shell M48A1 & M51 TNT M2	5,147,282
105MM Shell M48A1 & M51 TNT M3	5,913,283
105MM Shell M54 Amatol M2	2,415,904
105MM Shell M54 TNT M2	3,687,682
105MM Shell M54 TNT M3	786,589
105MM Shell W/O Fuze & Booster	47,173
105MM Shell M54 M2 T-Shell	17,420
105MM Shell M51 M2 T-Shell	437,512
GROUP 2.	
105MM Shell M2 T-Shell	177,066
105MM Shell M48A1 TNT M3	24,626
105MM Shell M48A1 TNT M2	519,600
155MM Shell M1A1	150,259
155MM Shell M101	2,098
155MM Shell M102	520,036
Anti-Tank Mine M1	988,348
Anti-Tank Mine M1A1	2,936,522
Anti-Tank Mine M4	111,543
250# Bomb AN-M57	130,477
500# Bomb AN-M64	10,771
155MM Shell M107	560,826
Cartridge Case Primed	500
240MM Shell W/Supp. Charge	32,160
240MM Shell W/O Fuze	193,512
GROUP 3.	
Anti-Tank Mine M5 W/O Fuze	96,701
Anti-Tank Mine M5 W/Fuze	71,384
Demolition Block Chain M1	180,140
Demolition Block Chain M2	1,161,680
105MM Shell - Barium	4,426
300# Bomb M31	309,778
250# Bomb TNT AN-M57A1	79,971
500# Bomb Amatol AN-M58	
500# Bomb TNT AN-M58	85,434
500# Bomb Amatol AN-M58A1	63,770
500# Bomb TNT AN-M64	
1000# Bomb Amatol Demo M44	54,057
1000# Bomb Amatol GP AN-M44	42,327
1000# Bomb Amatol GP AN-M65	4,118
2000# Bomb Amatol GP AN-M34	
2000# Bomb Amatol GP AN-M66	16,412
2000# Bomb TNT GP AN-M66	16,511
A.T. Mine Practice T3E1 W/Fuze	
GROUP 3A.	
500# Bomb TNT GP AN-M64	19,177
1000# Bomb Amatol Demo M44	
1000# Bomb Amatol GP AN-M44	55,238
1000# Bomb TNT GP AN-M65	165,134
1000# Bomb TRI AN-M65	4,904
2000# Bomb Amatol GP AN-M34	30,648
2000# Bomb Amatol GP AN-M56	29,140
4000# Bomb Amatol GP AN-M56	2,175
4000# Bomb TNT GP AN-M56	3,956
A.T. Mine T3E1 W/Fuze	1,921
A.T. Mine Practice T3E1 W/O Fuze	34,501
250# Bomb TNT M57A1	32,178
240MM Shell	1,422

ITEM	TOTAL PRODUCTION
GROUP 4.	
Fuze M48, M48A1	8,238,015
Fuze M48, M48A1 Inert	11,100
Fuze M73, Dummy	182,135
Supplementary Charge T2	647,892
A.T.M. Fuze & Booster Inert	1,200
Fuze A.T. Mine M5	94,600
Fuze A.T. Mine T3E1	34,169
GROUP 5.	
Fuze M48, M48A1	2,305,843
Fuze M51, M51A1	1,320,030
GROUP 6.	
Booster M20, M20A1	14,343,401
Booster M20, Inert	27,800
Booster Adapter M102	445,505
Booster Auxiliary M104	1,153,490
Booster Auxiliary M111	3,112
Booster Adapter M115	575,984
Fuze Bomb Nose M103	783,209
GROUP 7.	
Booster M21A4	[illegible],312,502
Booster M2[illegible] M20A1	3,836,103
Booster M21	[illegible],619
Booster Auxilia[illegible] 104	13,000
Booster A.T.M. M1A1	4,043,389
Fuze A.T. Mine M1	1,300,813
Fuze A.T. Mine M1A1	2,110,300
Fuze A.T. Mine M1A2	2,[illegible]2,569
Booster M115, M115A1	175,040
Booster M111	[illegible]00
GROUP 8.	
Primers M31	1,633,906
Primers M1B1A1, M1B1A2	45,495,569
GROUP 9.	
Detonator M15	4,970,[illegible]59
Detonator M20, M17	41,704,741
Detonator M24	2,[illegible]73,830
Detonator M48	[illegible],775,408
Detonator M1A2	[illegible],089,519
Detonator for M5 Fuze	285,176
Detonator for M5 Mine	129,661
Detonator for T8E1 Fuze	4,[illegible]58,739
Relay Assemblies M48	7,516,850
GROUP 61.	
Ammonium Nitrate EOP Liquor	72,400,103
Ammonium Nitrate Canadian Liquor	11,918,565
Ammonium Nitrate Crusher	18,860,207

ITEM	TOTAL PRODUCTION
RENOVATIONS.	
Refuze & Repack 105MM Shell M48 M2 M3	358,136
Change Cartridge Cases in 105MM Shell	129,389
Cleaning Shells	1,213,607
Change T29 Containers	1,990
Inert Shells Special Order	7,643
105MM Shell to be steamed out	
Fuze M103	13,166
Booster M115	16,839
Inspecting M48 Parts	88,003,200
Fuze A.T. Mine M1A2	997,342
Fuze M48 Drop Test	50,000
Fuze M48, M48A1	1,966,398
Fuze M51A1	77,820
Fuze Bodies M5	177,600
Disassemble M48 Fuze	61,809
Ream Rotor M20A1	502,410
Disassemble M1A1 Booster	110,848
Destroy M4 Fuze	33,915
Destroy T3E1 Fuze	7,982
Destroy M4 Booster	190,039
Detonator Assem. A.T.M. Fuze	689,512
M21A1 Booster Reassembled	34,733
105MM Shell Defuzed	11,986
105MM Shell Refuzed	54,478
105MM Shell Repacked	238,708
105MM Shell M54 Change Smokeless Powder	118,602
105MM Shell M54 Change Fuze	25,217
A.T. Mine Fuze Defuzed	129,003
M102A1 Booster	21,504
Disassembled Fuze A.T.M. M1	308,817
Demolition Block Pellets M1	2,941,141
Steam Out 105MM Shells	200,900
Bottom Closing Screw Assembly	147,099
Pellets for A.T. Mine M4	781,819
Ring Pellets for A.T.M. M5	137,240
Crescent Pellets for A.T.M. M5	367,754
Screen Tetryl	7,700
Cut Down M39A1 Containers	1,497,232
Unpacking Smokeless Powder	338,543
105MM Shell M54 - Repack	159
Projectile Change	
Anti-Tank Mine M4	134,448
Anti-Tank Mine Boxes	33,157
Ring Pellets for M5 Fuze	142,560
Solid Pellets for M5 Mine	73,600
M47 Containers	356,516
Stencil Demo Block Boxes	10,502
1000# Bomb	23,046
Primers M1B1A2	189,953
Shell for 4.5 Gun	1,503
155MM Shell - Group 61	18,164
155MM Shell - Cleaning	389,876
Inert Mine Special Order	998
M20A1 Booster Parts	61,924
155MM Shells MKA1 from Overseas	
75MM Shells	314,176
75MM Cartridge Cases	79,988
Flaking TNT	1,683,990
Depth Bomb	1,633
Detonator M17	666,000
Booster M21A4	24,100